

12/5/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200
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D2282-5

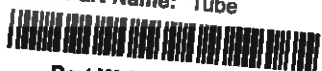
Job Sheet 204247



Part No: D2282-5

Part Name: Tube

Job Qty: 80 pcs



Part Weight: 0 lbs

Job Created: 12/5/19

Due Date: 1/22/20

Type: SOLD

Status: New

Job Tracking No:

Priority: Medium

Created By: Marie Lajeunesse

Description:

Note: DWG REV E IPP Rev:A Removed from 9 Digit 05-12-02 JLM IPPRev:B Now on Doosan Lathe 08-06-05 JLM
Verified By: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Workcenter / Supplier Lead Time
100	Doosan - 1	80 pcs		1/22/20	0.03	12.43	Doosan - 1	
120	QC 8	80 pcs		1/22/20	0.00	0.00		

Sign-off

[Signature]
19/12/23



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Container No: S242996



Part: D2282-5

Job No: 204247

Serial No/Batch: S242996

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/21/19

130 Packaging 3-1 - Stock - B4B 80 pcs

1/22/20

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

12/5/2019

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				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	QR
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	80 pcs	1/22/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	2.50

DEC 27 2019

Part Op 100 - (Doosan Lathe) 1-Turn as per Dwg D2282 and Folio FA189
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Identify as per dwg & Stock Location) *UACOL* *****STOCK IN LARGE FAB*****
 140 - (QC5- Inspect part completeness to step on W/O)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R0.750	304 SS Roundbar .750	14.4048 ft (.18006 ea)	100-Doosan - 1	S232320

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M304R0.750	14	28	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Handle Tube	2.170Inches $\pm$ 0.030	2.200 2.140	2.169	
2	Handle Tube	0.063Inches $\pm$ 0.010	0.073 0.053	.063	Radius
3	Handle Tube	0.063Inches $\pm$ 0.010	0.073 0.053	.062	
4	Handle Tube	0.125Inches $\pm$ 0.010	0.135 0.115	.126	
5	Handle Tube	0.090Inches $\pm$ 0.010	0.100 0.080	.089	
6	Handle Tube	45.000Degrees $\pm$ 0.000	45.000 45.000	45	Angle
7	Handle Tube	0.350Inches + 0.010 - 0.000	0.360 0.350	.358	Radius
8	Handle Tube	0.158Inches $\pm$ 0.010	0.168 0.148	.157	
9	Handle Tube	0.386Inches + 0.005 - 0.000	0.391 0.386	.387	Diameter
10	Handle Tube	0.700Inches $\pm$ 0.010	0.710 0.690	.7	Diameter

Plex 12/5/19 10:20 AM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐				DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐				Date: _____ Sequence #: _____ QTY Affected: _____		MRB (QSI042) _____																																	
Description Work Order Deviation						Disposition																																							
Completed By						Lead hand / Supervisor						QC / QA Coordinator																																	
Root Cause Operator ☐ ☐ ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ ☐ ☐ Material ☐ ☐ ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ ☐ ☐ Human Factors ☐ ☐ ☐ ☐ ☐						FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>												Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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